

NOTES

1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS
DRAWING REQUIREMENTS MANUAL.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
3. DIMENSIONS ARE IN INCHES.

- 4 LOW HEAD CAP SCREWS, FIND NO. 6, SHALL BE INSTALLED WITH LOCTITE, FIND NO. 7, IN ACCORDANCE WITH LOCTITE PROCEDURES AND TIGHTENED TO 35 IN.-LBS.

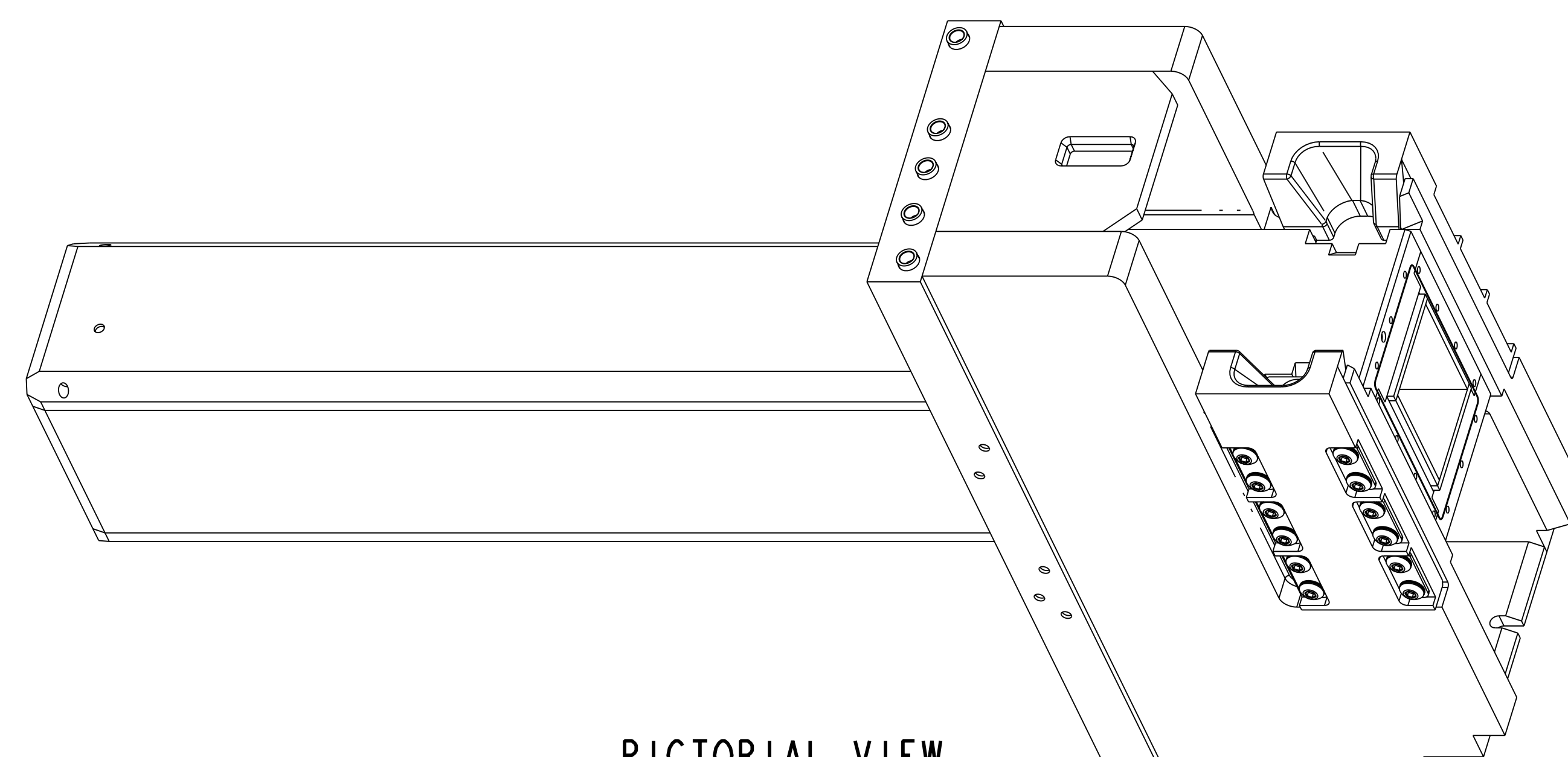
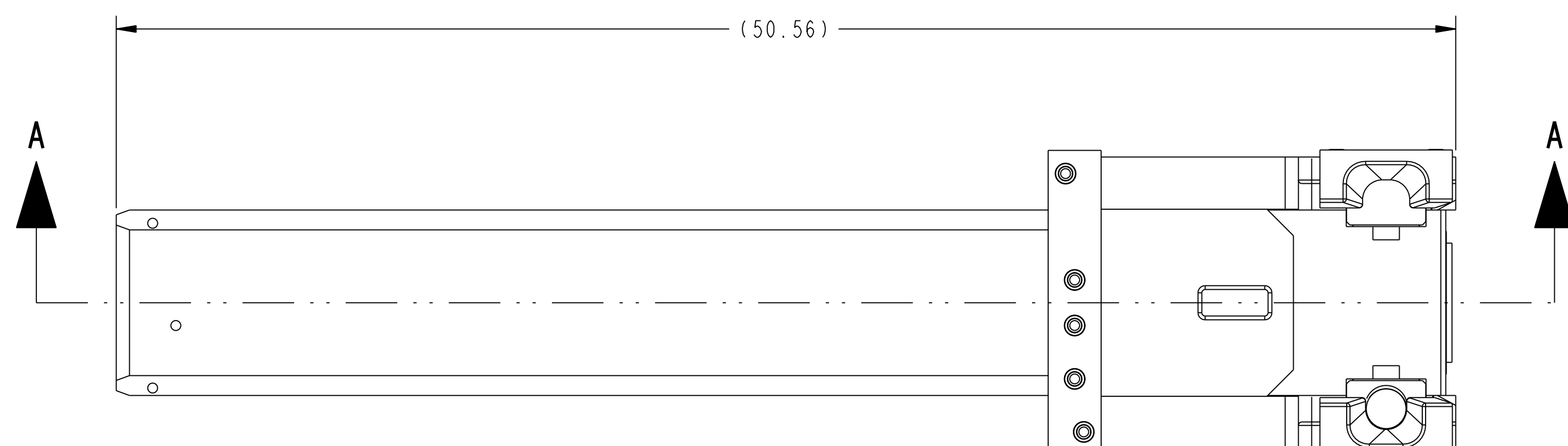
- 5 HELICOIL INSERTS, FIND NO. 5, SHALL BE INSTALLED PER
HELICOIL SPECIFICATIONS.

- 6 UNBRAKO DIV/SPS TECHNOLOGIES, 4444 LEE RD.
CLEVELAND OHIO 44128

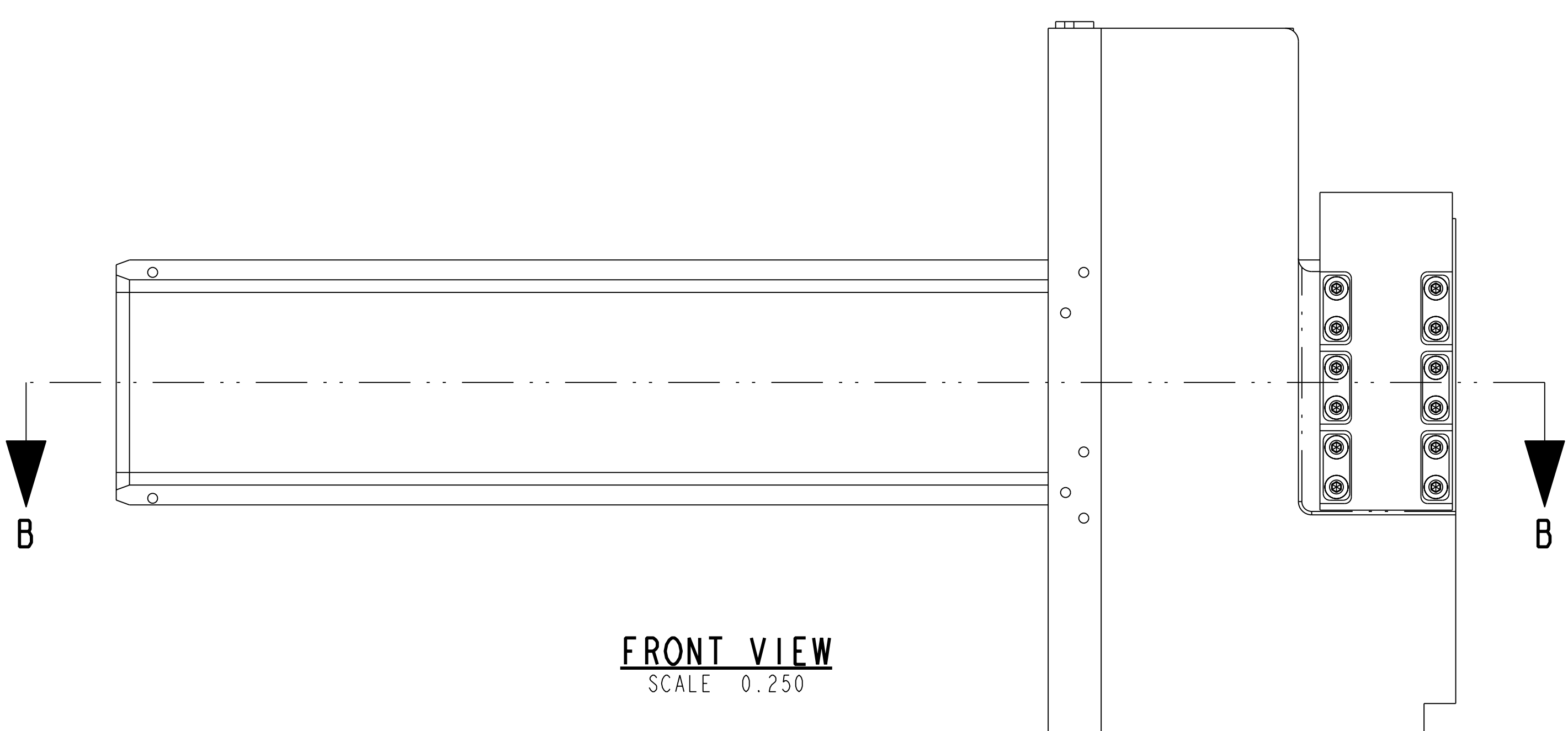
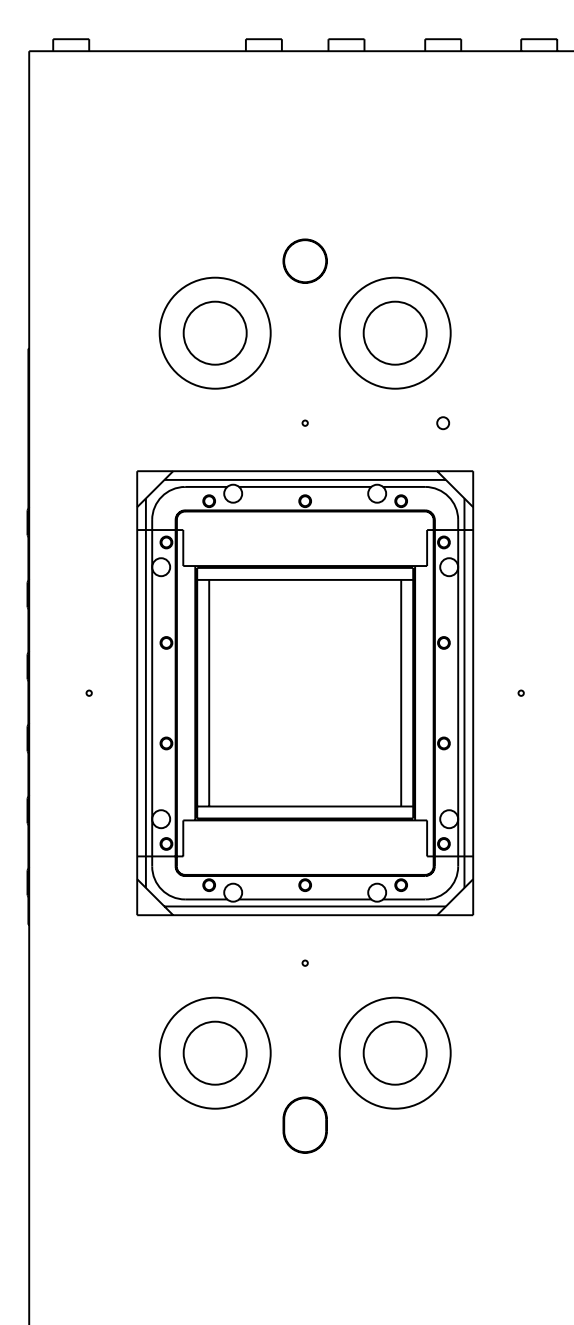
- 7 HELICOIL INSERTS REPRESENTATIVE:
EMHART FASTENING TECHNOLOGIES-INDUSTRIAL USA
3703 ERIN BROOK DRIVE
NEW PORT RICHEY, FL. 34655-2901
(727)327-3678

- 8 LOCTITE CORPORATION, 1001 TROUT BROOK CROSSING,
ROCK HILL, CT. 06067-3910.

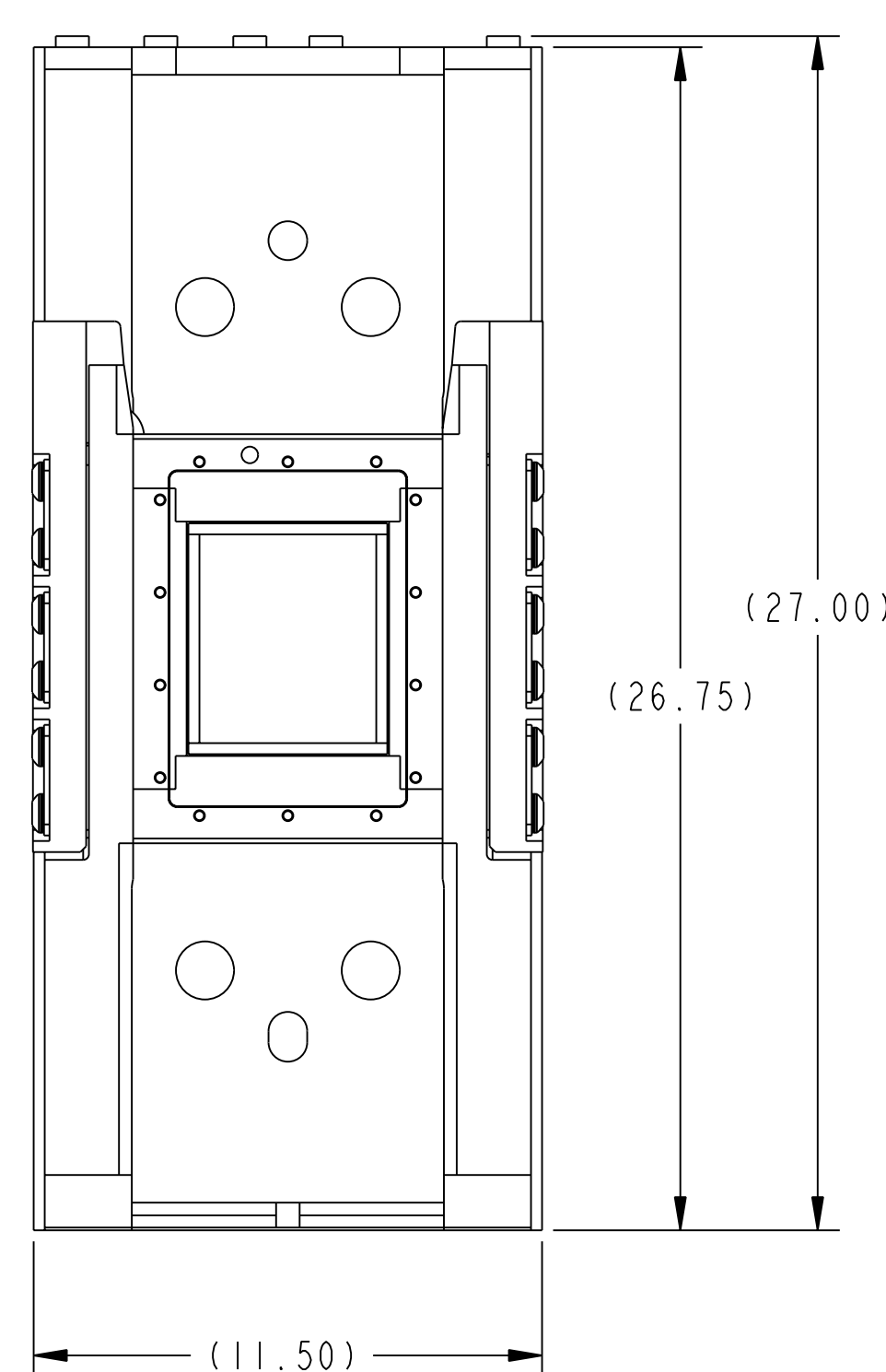
- 9 TORQUE LOW HEAD CAP SCREWS, FIND NO. 6, PER NOTE 4. TORQUE SCREWS IN THE SEQUENCE SHOWN ON SHEET 2, IN THE LEFT & RIGHT END VIEWS.



PICTORIAL VIEW
SCALE 0.250



FRONT VIEW
SCALE 0.250



		8
4	6	9
	5	7

07030600M08E8700A125	I	107030600M08E8700A179-I	DECOUPLER ASSEMBLY	--	--	3
	I	107030600M08E8700A127-I	WELDMENT W/GUIDE ASSEMBLY	---	---	2
	I	107030600M08E8700A126-I	WELDMENT/GUIDE/WINDOW ASSEMBLY	---	---	1
	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
			← NEXT ASSEMBLY	PARTS LIST		

PARTS LIST

QUALITY VERIFICATION		
MECHANICAL AND STRUCTURAL REFERENCE: SWS-15-0002		
QV	CLAUSE	DOCUMENTS REQUIRED APPLICABLE TO PART NO. *
30.3	MATERIAL WILL TEST REPORT	-
30.5	MATERIAL SELLER CERT	-
32.6	SPECIAL MATERIAL INSPECTION REPORT	-
30.5	NONCONFORMANCE, INSPECTION, AND TEST PLAN	-
31.2	FIELD INSPECTION AND TEST PLAN	-
32.1	WELD AND BRAZE INSPECTION REPORT	-
32.2	HEAT TREAT REPORT (INCHART)	-
31.0	LEAK TEST REPORT	-
31.5	CLEANING CERT	-
31.8	DECONTAMINATION REQUEST	-
31.9	NONCONFORMANCE PROCESS	-
32.3	DIMENSIONAL REPORT	-
33.0	FUNCTIONAL TEST REPORT	-
		-
		-
		-
		-
		-
		-
		-
		-
100	DOCUMENTATION	-

* SYMBOL 1 INDICATES APPLICABLE TO ALL PARTS OR ITEMS

RPE	
REV. XX	DATE XX/XX/XX

PRELIMINARY

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P THIS DRAWING PRODUCED
ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY
CHANGE CONTROL SYSTEM_____3_____
SNS PROCEDURE SNS-TS-000

[illegible]

SCALE AS NOTED

TOLERANCES
UNLESS OTHERWISE

	SPECIFIED
	FRACTIONS

XX DECIMALS	$\pm .0$
XXX DECIMALS	$\pm .00$

ANGLES	$\pm 0^{\circ} 15'$
BREAK SHARP EDGES	0.6 MAX


FINISH 125 RMS UNLESS
OTHERWISE SPECIFIED

--	--

DES		DMW/SMR	11/01
DRW	S.M. ROGERS		11/01
CHK	:	:	:
L3	:	:	:
L2	:	:	:
:	T.E. FORNEK		11/01
:	:	:	:
:	:	:	:
:	:	:	:
:	:	:	:
:	:	:	:
:	:	:	:
DRAWING APPROVALS			DATE

DATE _____

ornl Oak Ridge National Laboratory
operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725
Oak Ridge, Tennessee

 SNS Spallation Neutron Source

SPALLATION NEUTRON SOURCE PROJECT
SINGLE CORE VESSEL INSERT
SINGLE C.V. INSERT W/WINDOW

BLDG	FL	SHT	OF	CLAS
8700	1ST	1	2	U
E8700A126				REV
				B00

107030600M8E8700A126

CLASS	U
REV	
BOOK	

